

# Work Order ID 66208

February 7, 2011 12:47:27 PM



Page 1

Item ID: D4270-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: LVDT Bracket

Start Date: 2/07/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/02/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4270

PA1

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to 3.100"  
Batch: 107387

and 11/02/24

2 0

PTO →

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB004  
DWG REV: PA1  
FOLIO REV: AA

B.A 11/02/21

2 2

2- deburr rough edges



MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: [Signature] Date: 11/03/28

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/21	110	2 parts lifted in the vice during machining due to vibration. RC: Tooling was not rigid enough to hold the part properly	<u>[Signature]</u>	New tooling has been made to hold the part properly → scrap and destroy B 107387	G.A 11/03/21	<u>[Signature]</u> 11/03/29	<u>[Signature]</u>	<u>[Signature]</u> 11/03/28

NOTE: Date & initial all entries

# Work Order ID 66208

February 7, 2011 12:47:27 PM



Page 2

Item ID: D4270-3	Accept		Setup	Start	
Revision ID: PRELIM				Stop	
Item Name: LVDT Bracket					
Start Date: 2/07/11	Start Qty: 2.00		Cust Item ID:		
Required Date: 2/18/11	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo	0.00	B.A	11/03/21		2	2		
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00		GRK 11/03/21		2			
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00				2	BR 11-3-29		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66208**

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Page 3

Item ID: D4270-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: LVDT Bracket

Start Date: 2/07/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

inspected by PA1



QC

Memo

0.00

Dry only

Quality Control

(Aluminum) 8/10/09 (12)

180

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

AD 2334

POSITIVE RECALL

EFFECTIVE 11/02/07 AUTH U

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

pl 11-06-9  
(2)  
Eagle

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

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Work Order ID: 66208



Parent Item: D4270-3



Parent Item Name: LVDT Bracket

Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-24 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X01.50 0		Purchased	No			100	f	32.6833	0.258	0.543158			



6061-T6 Bar 2.50 x 1.50

Location

Loc Qty

Loc Code

MAT

32.68334

16742

32.68334

107387 X.543'

and 11/02/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 66208
<b>Description:</b> LVDT BRACKET	<b>Part Number:</b> D4270-3
<b>Inspection Dwg:</b> D4270 , Rev: PA1	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article     ☒ Prototype

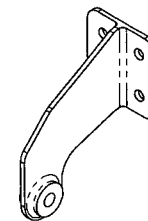
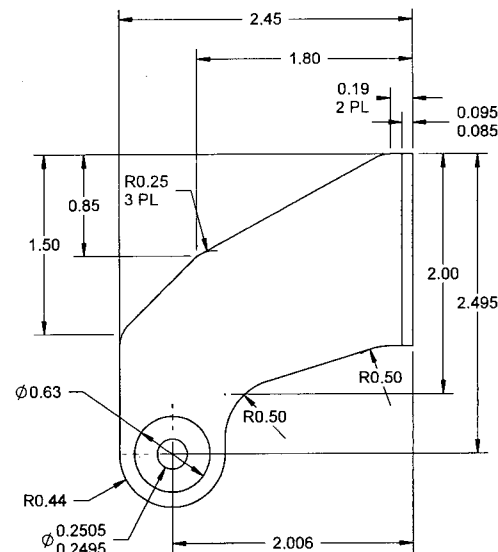
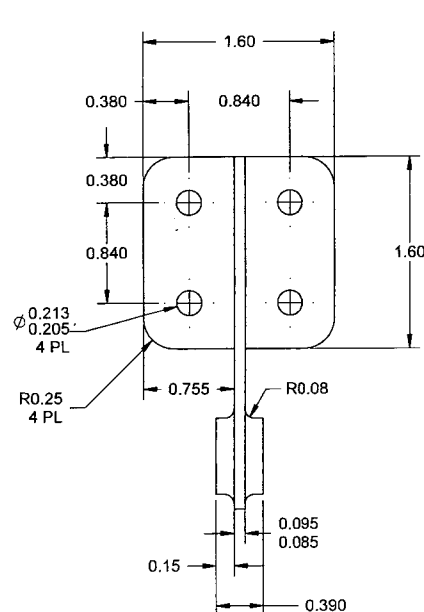
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.090	+/- .005	0.088	✓		Vern	GA-01
0.090	+/- .005	0.090	✓		"	"
R0.08	+/- .030	R0.063	✓		R-6	ref.
0.040	+/- .010	0.040	✓		H-6	31006
0.57	+/- .030	0.570	✓		Vern	GA-01
0.79	+/- .030	0.788	✓		"	"
0.380	+/- .010	0.381	✓		"	"
1.250	+/- .010	1.250	✓		"	"
0.380	+/- .010	0.381	✓		"	"
2.910	+/- .010	2.910	✓		"	"
2.150	+/- .010	2.150	✓		"	"
R0.50	+/- .030	R0.500	✓		R-6	ref.
R0.38	+/- .030	R0.375	✓		"	"
1.000	+/- .010	1.000	✓		Vern	GA-01
1.630	+/- .010	1.631	✓		"	"
φ0.205-0.213	min 0.205 / 0.213 max	φ0.208	✓		"	"
1.535	+/- .010	1.536	✓		H-6	31006
0.754	+/- .010	0.753	✓		"	"
φ0.50	+/- .030	φ0.501	✓		Vern	GA-01
R0.38	+/- .030	R0.375	✓		R-6	ref.
φ0.1905-0.1895	min 0.1895 / 0.1905 max	φ0.1905	✓		Vern	GA-01
R0.13	+/- .030	R0.125	✓		R-6	ref.
0.25	+/- .030	0.250	✓		Vern	GA-01

<b>Measured by:</b> H. g
<b>Date:</b> 11/03/21

<b>Audited by:</b> <i>[Signature]</i>
<b>Date:</b> 11/03/21

<b>Prototype Approval:</b>
<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



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66208  
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**D4270-1 BRACKET**

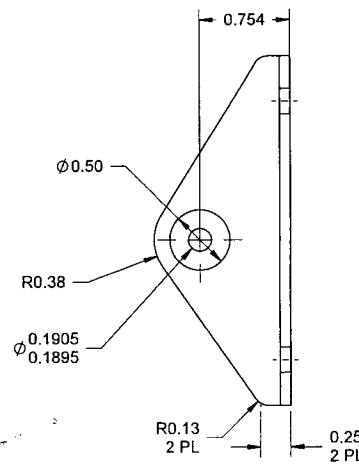
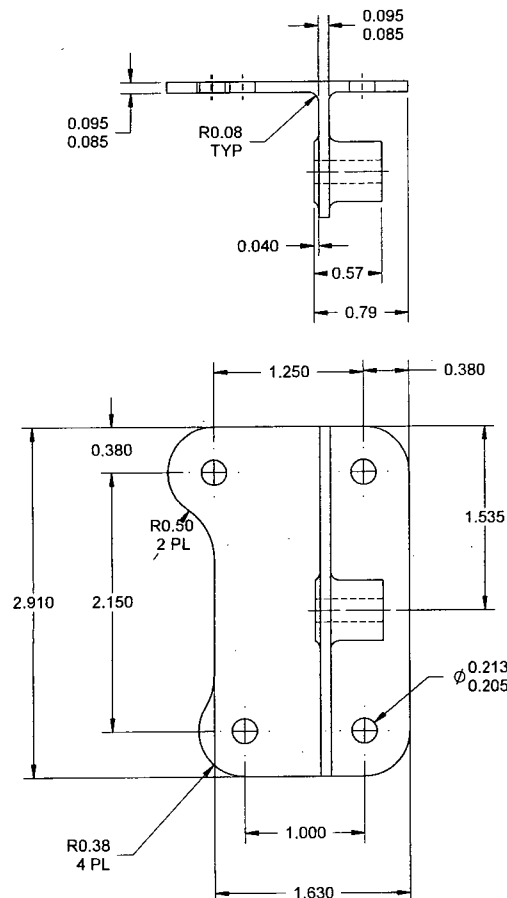
**PRELIMINARY ISSUE**

10.10.07

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 0.06 lbs

PA1~	NEW ISSUE		10.10.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.07		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4270</b>	REV. PA1
TITLE <b>LVDT BRACKETS</b>	SCALE NTS
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NO 66208

**D4270-3 BRACKET**

**PRELIMINARY ISSUE**

10.10.07

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
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  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4270</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>LVDT BRACKETS</b>	NTS
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